

Work Order ID 146989

Tuesday, May 24, 2016 11:23:18 AM

146989

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Item ID: D3969-9 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spring (Basket Lid)
Start Date: 5/24/2016 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 5/31/2016 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: **DAS** **13** **MAY 23 2016** Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3969	D								
100		0.00							DAS 13 9-19
100									58 MAY 23 2016
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 32457								
	Order as per Dwg D3969-9								
	Possible supplier: LS Technologies								
	part#: SSA4/8-130-343-360N								
	Material release note is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									5x 8/16-6-01
Packaging	Memo	0.06							
Packaging	***Measure compression only at 5mm on gas spring***								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo ***Measure compression only at 5mm on gas spring***	0.00 0.06				(5)			DAS 38 9-89 JUN 02 2016
130 *130* Small Fab Small Fab	Memo CRIMP END FITTING AT LOCATION SHOWN ON DWG (SEE NOTE 8)	0.00 0.24			DAS 30 9-89	5			JUN 02 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.06				(5)			DAS 38 9-89 JUN 02 2016

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: 54365	0.00				5		JUN 02 2016	DAG 6 9-55
150									
Packaging	Memo	0.03							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00						JUN 02 2016	
160									
QC	Memo	0.30							
Quality Control									

mf
16-5-1

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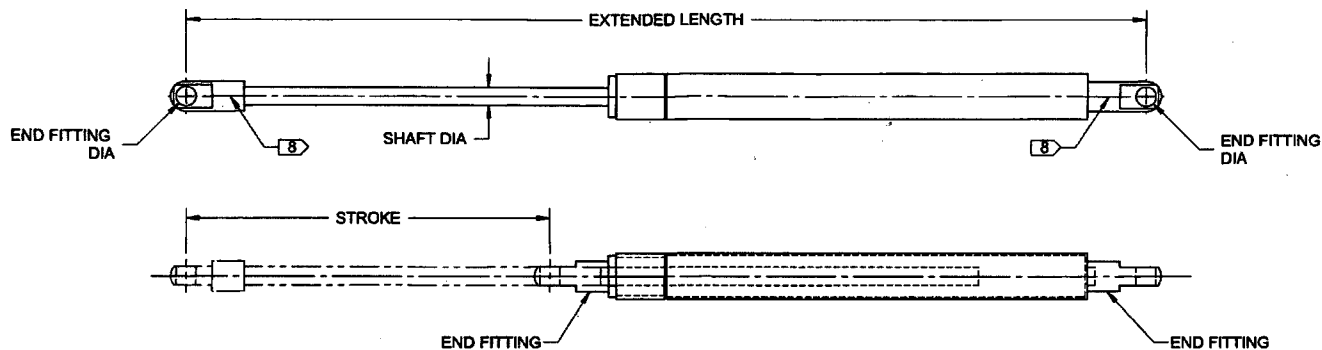
D3969-9

Required Qty: 3.00

Comments: IPP REV:A 16.05.24 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
SSA4/8-130-343-360N		Purchased	No				Each	0.0000		3			
SSA4/8-130-343-360N													
Gas Spring													
** 5x 2/16-6-01													

SPECIFICATION CONTROL DRAWING



D3969-X SPRING

MAY 23 2016

DAS
13
9-89

WID: 146988

DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERRED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	122/4.80	315/12.40	6/0.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs
D3969-3	122/4.80	315/12.40	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-310-360N	0.32 lbs
D3969-5	122/4.80	315/12.40	6/0.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-133N	0.27 lbs
D3969-7	122/4.80	315/12.40	6/0.24	222/50.0	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-225N	0.27 lbs
D3969-9	130/5.12	343/13.50	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-130-343-360N	0.35 lbs

△

NOTES:

- 1) MATERIAL: SEE CHART
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE CHART
- 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

RELEASED
2016-05-19
2016-581

APPROVED

D	ADDED -7/9	ML	16.05.12
C	REDRAWN IN SW. ADDED -3 & -5; ADDED SHAFT DIA COLUMN TO CHART. FORCE FOR -1 CORRECTED (WAS 60.9 lbs)	JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID). NOTE 8 ADDED.	AJS	09.11.10
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D3969	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET LID SPRING	NTS
DATE	16.05.12	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32457**

Purchase Order Date 5/24/2016

PO Print Date 5/24/2016

Page Number 1 of 2

Order From :

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

VC-LST0001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

REVISED

Contact Name

Vendor Phone 306 683 5000

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	B6-167-410-070N	Gas Spring	5/30/2016 Yes 5/30/2016		5.00 Each	\$26.50	\$132.50

AS PER DWG D3552-21 REV. L
B146988

Line Total: \$132.50

2	SSA4/8-130-343-360N	Gas Spring	5/30/2016 Yes 5/30/2016	FN	5.00 Each	\$65.00	\$325.00
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AS PER DWG D3969-9 REV. D
B146989

Line Total: \$325.00

Sp/16 ole-01

PO Instructions: Fedex Acc#151793240

Note:

5/24/2016

LS Technologies Inc
314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

Packing Slip

P.O. No.	Date	Invoice #
32457	5/31/2016	14913

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
5/31/2016	Fed-Ex	

Qty	Description
✓ 5	D3552-21-B146988 Gas Spring
5	D3969-9 B146989 Stainless Gas Spring
Shipping Via FED EX Tracking # 776408907325	
Sp/6-06-16	

Order checked by : 



LS Technologies Inc
314 Jessop Ave
Saskatoon, SK, S7N 1Y6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

May 31 2016

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

5 Units: D3552-21 B146988 Gas Spring (B6-167-410-070N) Carbon Steel Gas Spring

5 Units D3969-9 B146989 Stainless Gas Spring (SSA4/8-130-343-360N)

Country of Manufacture: Canada

Date of Manufacture : May 2016

This product is ROHS compliant.

Purchase Order # 32457

Invoice # 14913

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
Manager